

Date: Thursday, 1/17/2008 3:32:08 PM  
 User: Kim Johnston

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WINDOW FRAME
Job Number :	36857		
Estimate Number :	10624		
P.O. Number :		Part Number :	D2956
This Issue :	1/17/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2956 REV C
First Issue :	1/1	Project Number :	N/A
Previous Run :	33063	Drawing Revision :	C
		Material :	
Written By :	<u>JA 08 01 18</u>	Due Date :	1/31/2008
Checked & Approved By :	<u>JA 08 01 18</u>	Qty:	20 Um: Each
Comment :	Est. A 00.01.14 New issue EC Est Rev:B Now on Waterjet 07-06-25 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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71.



Comment: Qty.: 3.3907 sf(s)/Unit Total : 67.8132 sf(s)

5052-H32 .040 Sheet

Material: 5052-H34 sheet 0.040" thick.

Batch 106900 IB 8-1-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2956

Dwg Rev: CProg Rev: CIB 8-1-23

(21)

2-Debur if necessary

IB 8-1-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-1-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/01/04 (21)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JA08-01-28

(X21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 08/01/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:32:08 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW FRAME

Job Number: 36857

Part Number: D2956

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



101/06379



(21)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DR 08-01-28

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-29

(21)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 209

8/1/30

(21x)

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(21)

Comment: FINAL INSPECTION/W/O RELEASE

208/01/31

Job Completion



Li 08-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

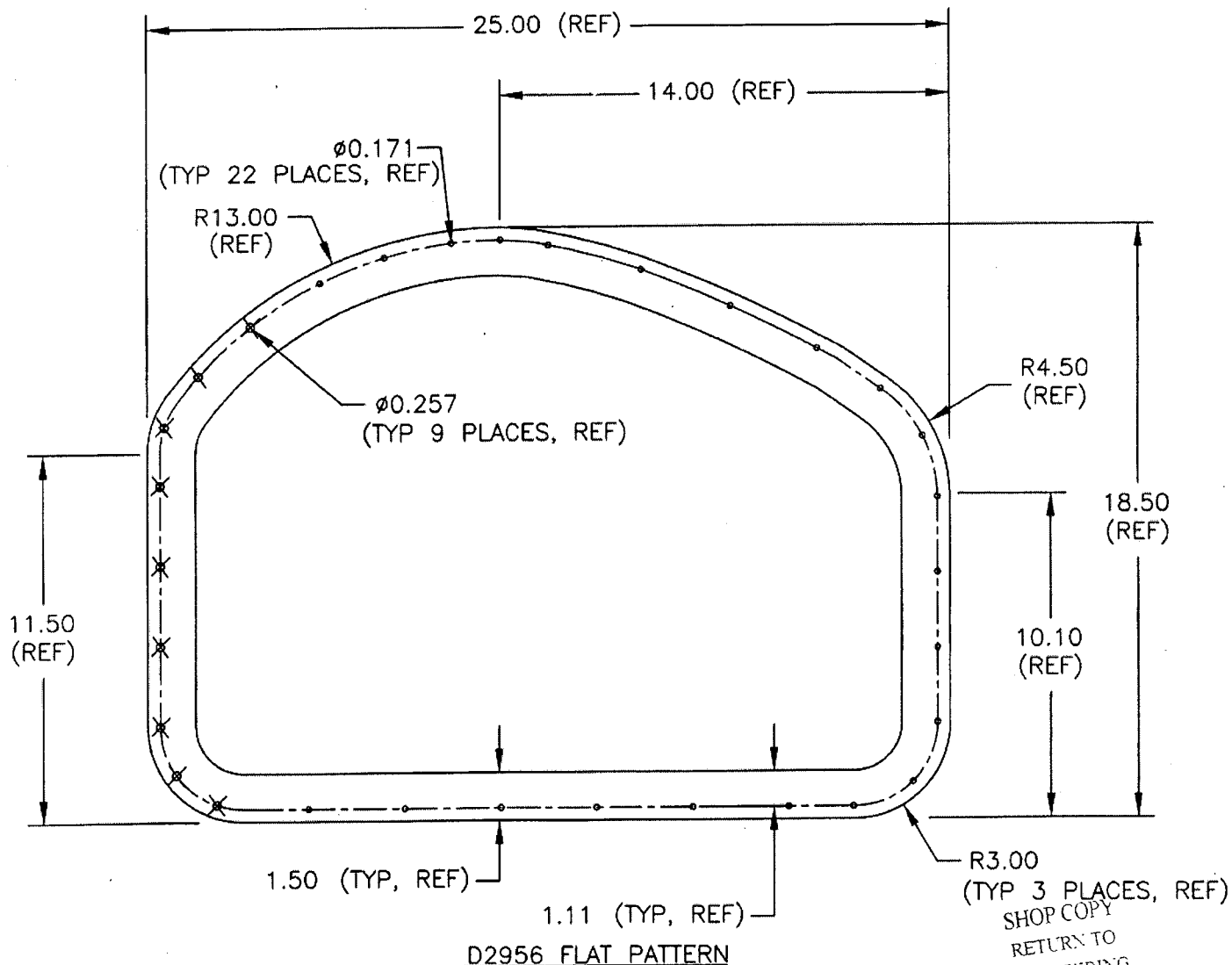
**NOTE:** Date & initial all entries





DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2956	REV. C SHEET 1 OF 1
DATE 01.06.04		TITLE WINDOW FRAME	SCALE 1:5
A	00.01.20	NEW ISSUE	
B	00.02.23	Ø0.141 HOLES WERE Ø0.128 (NCR 407)	
C	01.06.04	REMOVE Ø0.141 HOLES	

RELEASED  
01.06.05



D2956 FLAT PATTERN

MACHINE PER DRAWING FILE "D2956-C1.DWG"

CHECK HOLES PER TEMPLATE DT8437

BEND PER TEMPLATE DT8567

MATERIAL: 5052-H34 (QQ-A-250/8) SHEET 0.040 THICK

FINISH: POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3

ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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